

Work Order ID 123915

August-29-14 7:55:57 AM

D350-591-312

123915

Page 1

Item ID: D350-591-312

Revision ID:

Item Name: Heli-Access-Step™ RH

Start Date: 8/29/14 Start Qty: 2.00

Required Date: 8/29/14 Req'd Qty: 2.00

Reference:

B123915

REV-B

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: MC

Date: 14-08-29

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set-Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3272	Rev B

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

DAS
38
9-89

14-9-12

110

0.00

110

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod

3-Grind End Plate flush

B128956

B128316

2x CC 14-9-3

DMC 14-9-3

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Page 2

Reference:

Run	Start	*NR1*
	Stop	*NR2*

120

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

Set Up/ Run Hours

0.00

0.00

Tool ID	Tool #	Plan Code
---------	--------	-----------

—

14.09.08

DAS
9
9-89

130

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

②

14.09.00

DAS
9
3-89

140

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

6

14-09-05

DMC

Work Order ID 123915

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Page 3

Item ID: D350-591-312 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Access-Step™ RH
Start Date: 8/29/14 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 8/29/14 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.00				2	7/14/14	95	
Quality Control									
180	Large Fab	0.00							
180									
Large Fab	Memo	0.00				2			
Large Fab	1-Assemble Leg Assembly as per Dwg D3272.								
	2-Leave one rivet out until welding is complete.								
	3-Bevel Aft end for welding								
	4-Inspect for foreign object as per QSI 024								
	5-Weld Aft End Plate as per QSI 004 & Dwg D3272								
	A/RAluminum Rod <u>5128956</u>								
	6-Grind End Plate flush								
	7-Install last rivet as per Dwg.								

CC 14-8-9

CC 14-8-10

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[illegible]

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Item ID: D350-591-312

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Heli-Access-Step™ RH

Stop

NS2

Start Date: 8/29/14

Start Qty: 2.00

2

Cust Item ID:

Required Date: 8/29/14

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

220

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

2

14-9-11

DAS 34 9:59

230

Wing Walk as per dwg QSI005 4.4 Batch

0.00

230

HandFinish

Hand Finishing

Memo

0.00

x212H

14-9-11

240

QC3- Inspect Part Finish

0.00

240

QC

Quality Control

Memo

0.00

2

DAS 38 9:59

14-9-11

Work Order ID 123915

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Item ID: D350-591-312

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Heli-Access-Step™ RH

Stop

NS2

Start Date: 8/29/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 8/29/14 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250									
Packaging	Memo	0.00				2X	DAS 28 9-89	SEP 10 2014	DAS 86 9-89
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.00				2			DAS 38 9-89 14-9-12
Quality Control									
270	Packaging	0.00							
270									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-312								
	Location: <u>Hall</u>								68-6 90 SVO

SEP 12 2014

Work Order ID 123915

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Item ID: D350-591-312

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step™ RH

Stop ***NS2***

Start Date: 8/29/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 8/29/14 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21 - Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

14/9/16

H4-9-15

Picklist Print

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Page 1

Work Order ID: 123915

123915

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH

Start Date: 8/29/14

Required Date: 8/29/14

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:A04.03.22New issue KJ/RF
 IPP Rev:B 07-06-09 Added D3572-1 JLM
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
 IPP Rev:D 08-04-08 ECN1164 DD verified by:EC IPP Rev:D
 fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3272-1		Manufactured	No			110	Each	30.0000	1	2			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D3272-1

Step

DMC 14-8-29

Location	Loc Qty	Loc Code
WA003 <u>B123916</u>	30	
123345	10	
123346	10	
123348	10	

D3067-1		Manufactured	No			110	Each	414.0000	1	2			
---------	--	--------------	----	--	--	-----	------	----------	---	---	--	--	--

D3067-1

End Plate

CC 14-9-3

Location	Loc Qty	Loc Code
WA003	414	B117776
101785	67	
102686	14	
<u>117776</u>	183	
119290	150	

D3219-1		Manufactured	No			110	Each	167.0000	2	4			
---------	--	--------------	----	--	--	-----	------	----------	---	---	--	--	--

D3219-1

Plate

CC 14-9-3

Location	Loc Qty	Loc Code
WA003	167	
112125	8	
<u>114934</u>	40	
115339	119	

(4x)

Picklist Print

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Page 2

Work Order ID: 123915

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step™ RH

123915

D350-591-312

Start Date: 8/29/14

Required Date: 8/29/14

Start Qty: 2.00

Required Qty: 2.00

D3066-1 Manufactured No

180 Each 168.0000 2 4

D3066-1

Spacer

**

CC 14-8-9

Location

Loc Qty

Loc Code

WA003

168

106302

7

52

115868

52

115869

40

117799

17

MS20600-AD4W4

Purchased No

180 Each 2,909.000 16 32

MS20600-AD4W4

Rivets

**

CC 14-8-9

Location

Loc Qty

Loc Code

ST310

2909

125577

215

M128899

2694

D3065-041

Manufactured No

180 Each 13.0000 1

D3065-041

Step Leg Assembly

**

CC 14-8-9

Location

Loc Qty

Loc Code

WA003

13

102830

6

109447

2

113075

2

115697

3

~~B123387~~
~~B103378~~

2x

Picklist Print

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Page 3

Work Order ID: 123915

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step™ RH

123915

D350-591-312

Start Date: 8/29/14

Required Date: 8/29/14

Start Qty: 2.00

Required Qty: 2.00

D3067-1

Manufactured No

180

Each

414.0000

1

2

D3067-1

End Plate

CC 14-8-29

Location

Loc Qty

Loc Code

WA003

414

101785

67

102686

14

117776

183

119290

150

AN3-35A

Purchased

No

250

Each

149.0000

2

4

AN3-35A

Bolt

DAS
38
9-89

SEP 1-0 2014

Location

Loc Qty

Loc Code

FG

10

122800

10

ST348

139

m129706

39

m129934

100

D3235-1

Manufactured

No

250

Each

343.0000

2

4

D3235-1

Mounting Lug

DAS
38
9-89

DAS
28
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST519

343

102818

6

105939

17

108670

43

114441

54

116383

100

116384

53

116385

70

DAS
28
9-89

DAS
06
9-89

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Shop Packet Print

Page 3

Picklist Print

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Page 4

Work Order ID: 123915

123915

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH

Start Date: 8/29/14

Required Date: 8/29/14

Start Qty: 2.00

Required Qty: 2.00

D3278-041

DAS Manufactured No

250

Each

69.0000

1 2

D3278-041

38

9-89

Support Assembly

DAS

28

9-89

SEP 1 0 2014

Location

Loc Qty

Loc Code

ST521

69

102349

1

109406

1

114169

39

114940

4

121431

24

NAS1149D0463J

Purchased

No

250

Each

6,237.000

16 32

NAS1149D0463J

DAS

38

9-89

WASHER

DAS

28

9-89

Location

Loc Qty

Loc Code

CA

485

M129682

485

ST277

5752

16941

8

M126221

20

M127813

6

M127904

127

M128591

44

M128995

1500

M129390

4047

32x

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Shop Packet Print

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Picklist Print

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Page 5

Work Order ID: 123915

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step™ RH

123915

D350-591-312

Start Date: 8/29/14

Required Date: 8/29/14

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0563J

Purchased **DAS**
38
9-89

No

250

Each

1,991.000

8

NAS1149D0563J

Washer

DAS
28
9-89

SEP-10 2014
DAS
06
9-89

Location

Loc Qty

Loc Code

GA	125
m125807	125
ST510a	1866
m126319	100
m128257	1766

250

Each

91.0000

4

AN5-36A

Purchased

No

AN5-36A **DAS**
38
9-89

Bolt

DAS
28
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST336	91
M126105	1
M127410	7
M127460	83

250

Each

211.0000

2

4

D2618

Manufactured

No

D2618

Bushing

DAS
38
9-89

DAS
28
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST008A	211
103863	3
114872	1
123045	100
97780	107

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Picklist Print

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Work Order ID: 123915

123915

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH

Start Date: 8/29/14

Required Date: 8/29/14

Start Qty: 2.00

Required Qty: 2.00

D2230-3

DAS
38
9-89

Manufactured No

250

Each

458.0000

4 8

D2230-3

Mounting Lug

SEP 10 2014

Location

Loc Qty

Loc Code

FG

7

109344

4

89045

3

ST519

451

108668

1

109344

2

114151

1

114921

4

115583

146

116378

155

116379

142

DAS
38
9-89

Manufactured No

250

f

214.0000

1.2

3

DAS
28
9-89

DAS
06
9-89

DAS
28
9-89

DAS
06
9-89

D2856-400

D2856-400

Abrasion Strip 4" Wide (Per Foot)

Location

Loc Qty

Loc Code

ST426

214

117887

214

123583

cut (2) D2856-400-720 as per dwg

MS21042L3

Purchased

No

250

Each

3,205.000

2

4

MS21042L3

Nut

DAS
38
9-89

Location

Loc Qty

Loc Code

ST307

3205

123900

948

M127410

11

M127831

41

M128401

42

M128754

2163

DAS
28
9-89

4X

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Shop Packet Print

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Picklist Print

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Page 7

Work Order ID: 123915

123915

Parent Item: D350-591-312

D350-591-312

Parent Item Name: Heli-Access-Step™ RH

Start Date: 8/29/14

Required Date: 8/29/14

Start Qty: 2.00

Required Qty: 2.00

AN4-13A DAS Purchased No

250

Each

663.0000

8

16

AN4-13A

Bolt

DAS
38
9-89

**

DAS
28
9-89

SEP 10 2014

Location

Loc Qty

Loc Code

CA	2
m129682	2
FG	20
122808	20
GA	14
m125709	14
ST515	627
m127432	36
m127817	22
m128739	569

MS21042L5

MS21042L5

Nut

DAS
38
9-89

Purchased

No

250

Each

672.0000

2

4

**

DAS
28
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST307	672
125684	8
m127304	1
m127813	497
m128810	7
m129472	159

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Shop Packet Print

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Picklist Print

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Work Order ID: 123915

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step™ RH

123915

D350-591-312

Start Date: 8/29/14

Required Date: 8/29/14

Start Qty: 2.00

Required Qty: 2.00

MS21042L4

DAS
38
9-89 Purchased

No

250

Each

4,918.000

8

16

MS21042L4

Locknut

**

DAS
28
9-89

SEP 10 2014

DAS
38
9-89

Location

Loc Qty

Loc Code

ST307

4918

126275

5

m126015

12

m126275

27

m127255

63

m127376

11

m127813

891

m128300

80

m128798

1329

m129472

1000

m129934

1500

16x

NAS1149D0363J

Purchased

No

250

Each

1,765.000

4

8

NAS1149D0363J

Washer

DAS
38
9-89

**

DAS
28
9-89

DAS
38
9-89

Location

Loc Qty

Loc Code

GA

23

124392

23

ST276

5

m123441

5

ST510a

1737

m128429

1737

8x

August-29-14 7:56:03 AM

Shop Packet Print

Page 8

DART

DESIGN <i>qp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07.06.04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 123915 MJS

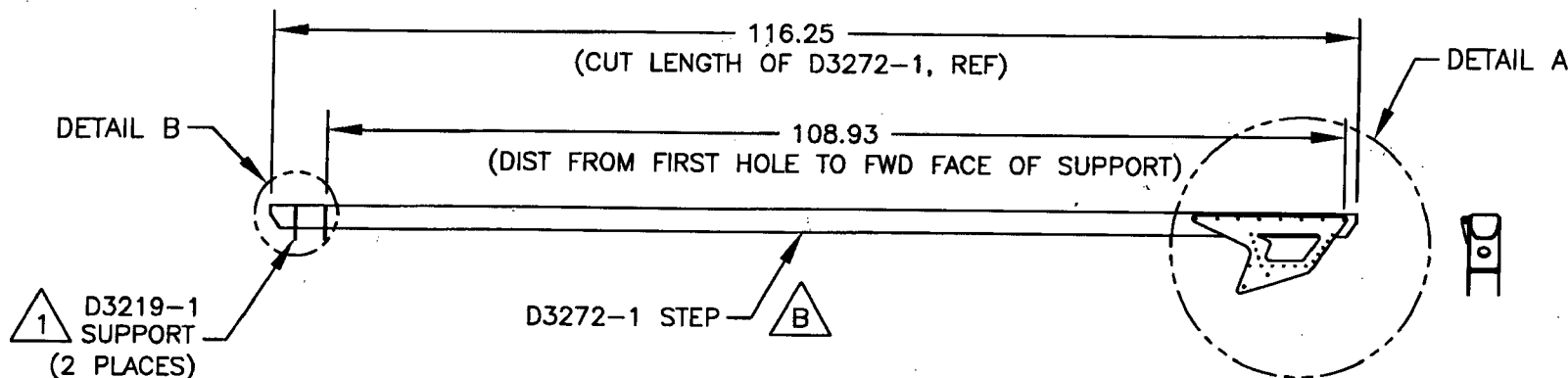
140829

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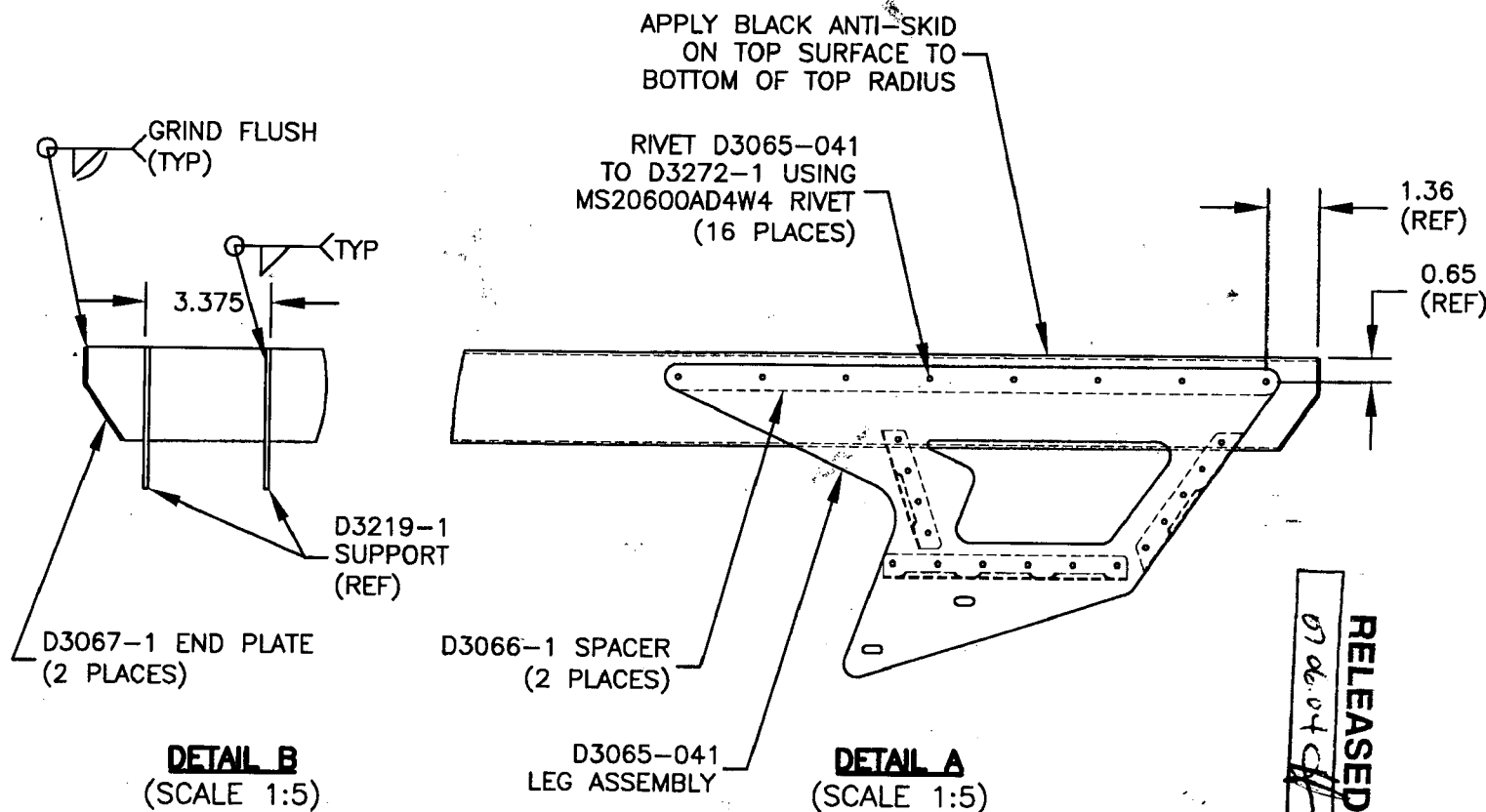
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DART

DESIGN	<i>CP</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>CE</i>	APPROVED	<i>CP</i>	DRAWING NO. D3272
DATE	07.05.18	TITLE	STEP ASSEMBLY, HI LONG	REV. B
		SCALE	1:20	SHEET 2 OF 3



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

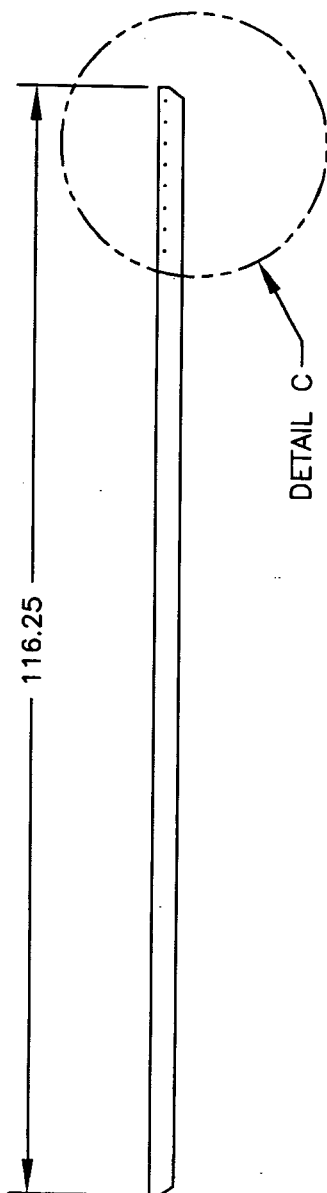




DESIGN <i>qp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

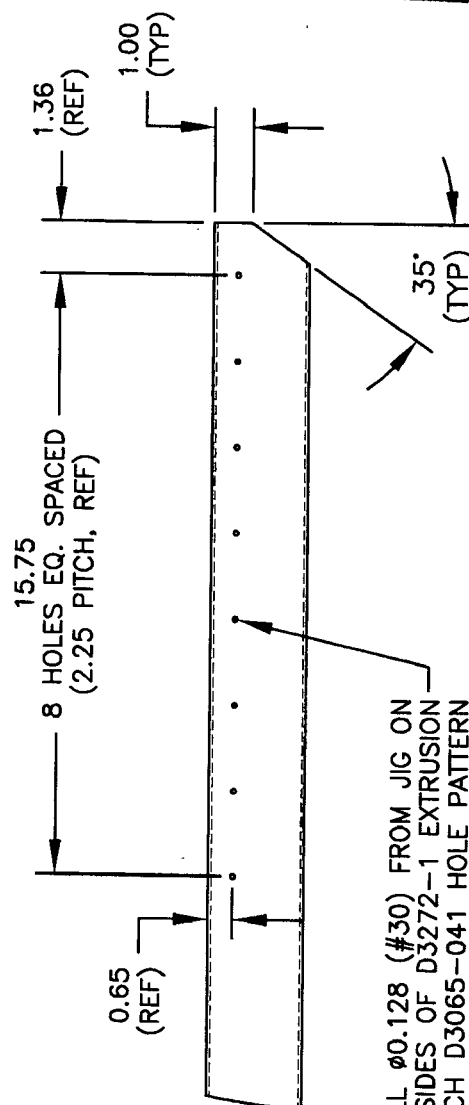
07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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Work Order ID 123915

123915

Page 1

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Item ID: D350-591-312

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step™ RH

Start Date: 8/29/14 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 8/29/14 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-09-29

Tooling:

Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3272	Rev B								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc. Control-USB or Paperwork	Photocopy bluefile and type labels as per PPP D350-591-312 CHG001								
110	Large Fab	0.00							
110	Large Fab	0.00							
Large Fab	Memo								
Large Fab	1-Bevel end for welding FWD ONLY								
	2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272								
	A/R Aluminum Rod B128956								
	3-Grind End Plate flush B1289316								

MLJ

14-09-11

2

24 CC 14-9-3

DMC 14-9-3